



Dart Aerospace Ltd.
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D4131-043
Job Sheet 184683



ASAP

shp Nov, 2

Part No: D4131-043

Job Qty: 5 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,9 IPP Rev:A 10.10.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	5 pcs		10/31/18	0.00	0.56	Waterjet 1		<i>X 10/18/18</i>
120	QC	5 pcs		10/31/18	0.00	0.00	QC8		<i>38</i>
130	Small Fab	5 pcs		10/31/18	0.00	0.32	Small Fab-6		<i>9-89 DAS</i>
150	QC	5 pcs		10/31/18	0.00	0.00	QC5		<i>38</i>
160	HandFinish	5 pcs		10/31/18	0.00	0.28	HandFinish1		<i>8-23-18-10-89</i>
161	QC	5 pcs		10/31/18	0.00	0.00	QC7-3		<i>38</i>
165	Small Fab	5 pcs		10/31/18	0.00	0.32	Small Fab-6		<i>38</i>
166	QC	5 pcs		10/31/18	0.00	0.00	QC5		<i>38</i>
180	Packaging	5 pcs		10/31/18	0.00	0.00	Packaging3-2	<i>5-079</i>	<i>NOV 0 1 2018</i>
190	QC21-SA	5 Ea		10/31/18	0.00	0.00	QC21		<i>NOV 0 5 2018</i>

Part Op 100 - 1-Cut D4131-7 as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr as required
Descriptions: 130 - COUNTER SINK AS PER DWG Deburr if necessary.
165 - ASSEMBLE NUT PLATES AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.9035 sf (.1807 ea)	100-Waterjet	<i>5105486</i>
MS20426AD3-3	Rivet	40 Ea (8 ea)	165-Small Fab	<i>5018535</i>
MS21069L3	Anchor Nut	20 Ea (4 ea)	165-Small Fab	<i>5050044</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.063	1	160	0
165-Small Fab	MS20426AD3-3	40	3,180	0
	MS21069L3	20	116	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	<i>0.099</i> Diameter	
2	Doubler Assembly	0.191Inches + 0.005 - 0.001	0.196 0.190	<i>0.191</i> Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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4	Doubler Assembly	0.500Inches ± 0.010	0.510 0.490	0,504
5	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0,409
6	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0,408
7	Doubler Assembly	0.590Inches ± 0.030	0.620 0.560	0,589
8	Doubler Assembly	0.660Inches ± 0.030	0.690 0.630	0,666
9	Doubler Assembly	3.640Inches ± 0.030	3.670 3.610	3,644
10	Doubler Assembly	4.000Inches ± 0.010	4.010 3.990	4,002
11	Doubler Assembly	4.100Inches ± 0.030	4.130 4.070	4,101
12	Doubler Assembly	4.810Inches ± 0.030	4.840 4.780	4,814
13	Doubler Assembly	4.600Inches ± 0.010	4.610 4.590	4,607
14	Doubler Assembly	5.410Inches ± 0.030	5.440 5.380	5,414
15	Doubler Assembly	0.063Inches ± 0.010	0.073 0.053	0,060

Plex 10/16/18 8:13 AM Dart.lajeunesse.marie

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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